

Work Order ID 118371

July-11-14 8:01:11 AM

118371

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Item ID: D2138-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge Assembly - Upper

Start Date: 7/11/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/11/14 Req'd Qty: 2.00 *2* Customer:

Reference: re-powdercoat

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2138	Rev B

101

0.00

101

Small Fab

Small Fab

Memo

PULL FROM STK:
2 X D2138-042 B7582

DISASSEMBLE, PUT HARDWARE ASIDE TO RE-ASSEMBLE

105

0.00

105

Powdercoat

Powder Coating

Memo

SCUFF

RE-POWDERCOAT WHITE PER QS1005

M 128959 START: 10:00
 OVEN T: 320°
 FINISH: 10:30.

DAS
76
9-89

DAS
34
9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC3- Inspect Part Finish	0.00				2x			14/07/11 ES
110									
QC	Memo	0.00							
Quality Control									
120		0.00				2x			14/07/11 ES
120									
Small Fab	Memo	0.00							
Small Fab	RE-ASSEMBLE WITH ORIGINAL HARDWARE								
125	QC5- Inspect part completeness to step on W/O	0.00				2			
125									
QC	Memo	0.00							
Quality Control									

DAS
27
9-09
4/7/11

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Item ID: D2138-042 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 7/11/14 Req'd Qty: 2.00 ***2*** Customer:
Reference: re-powdercoat

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
135	QC21- Final Inspection - Work Order Release	0.00							
135									
QC	Memo	0.00							
Quality Control									

MLJ 14-07-11

Picklist Print

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Parent Item: D2138-042

D2138-042

Parent Item Name: Hinge Assembly - Upper

Start Date: 7/11/14

Required Date: 7/11/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2138-042		Manufactured	No				Each	7.0000		2			
D2138-042									**				
Hinge Assembly - Upper													

Location

Mezz

7582

Loc Qty

7

7

Loc Code

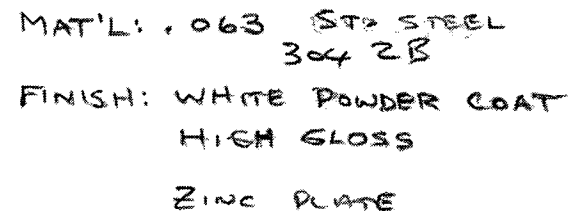
2 W-407-11

D2141

B 120887

4K

14/07/11 ES.

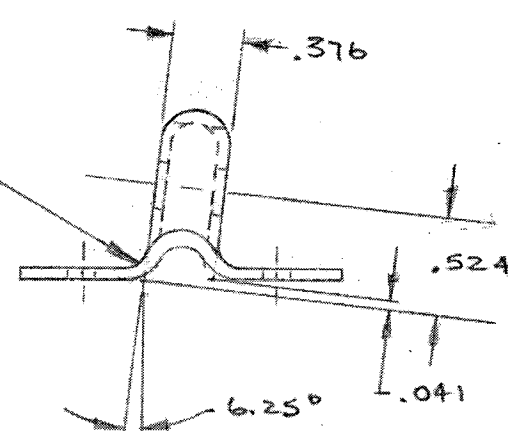


SUPERCEDED BY



D2957 rev A
06.12.15 K5

96109/05 B7D

DINWAD



SHOWN (LOWER)
OPPOSITE (UPPER)

B	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
		DRAWN		BASIC CODE	DIA. DASH NO. H-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO.		 DART AERO ACCESSORIES INC. VANCOUVER CANADA		
STENCIL STAPLES	3.30 DIM. 4/13/72 BODGE	APPROVED	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED	D-DIMPLE D-DIMPLE NO. OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN HATTON	DATE 07-07-72	DESIGN Boddy	92/7/74	
		DESCRIPTION OF CHANGE	GENERAL	LIMITS	BASIC CODES		TITLE HINGE BRACKET	CODE	DWG. NO. D 2138	
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 μ 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER INCH — 27-27.5 5. HOURS PER AND 10007	1. TOLERANCES — .001 & .030 .002 & .010 2. ANGLES 1° 3. PARALLELISM .005 4. ECCENTRICITY .005 MAX. 5. SYMMETRY ABOUT ALL M.P.C. CENTRE LINES .005	8J-M12047040 8B-M12042640	CHECKED Lewney	92/7/74	SCALE 1:1	SHT. 1 OF 1	
REPORT ALL DISCREPANCIES — DO NOT SCALE										